



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D2374
Job Sheet 177172



Part No: D2374

Job Qty: 20 ea

Part Name: Stud



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP D 03.04.04 Reformat; Made on Cobra KJ/RF IPP Rev:E Now on Doosan Lathe 08-05-05
JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	6/6/18	6/6/18	0.00	0.00	Start Up Machining		
100	Doosan	20 pcs	6/6/18	6/6/18	0.07	3.29	Doosan		
120	QC	20 pcs	6/6/18	6/6/18	0.00	0.00	QC8		
130	Packaging	20 pcs	6/6/18	6/6/18	0.00	0.00	Packaging3		
140	QC21-SA	20 Ea	6/6/18	6/6/18	0.00	0.00	QC21		

Part Op 100 - 1- Turn as per Folio FA156 Rev: _____ & Dwg D2374 Rev: _____ 2- Mill as per Folio FA156 Rev: _____ & Dwg
Descriptions: D2374 Rev: _____ 3-Deburr per dwg D2374

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINR1.000	Delrin Round Bar 1" Color: Black	2.5420 ft (.1271 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINR1.000	3	17	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Stud	1.000Inches ± 0.010	1.010 0.990	1.001"	
2	Stud	0.625Inches ± 0.010	0.635 0.615	0.625"	
3	Stud	0.500Inches + 0.005 - 0.000	0.505 0.500	0.501" Diameter	
4	Stud	0.313Inches + 0.005 - 0.000	0.318 0.313	0.314" Diameter	
5	Stud	0.062Inches ± 0.010	0.072 0.052	0.062" Radius	
6	Stud	0.300Inches ± 0.010	0.310 0.290	0.297"	
7	Stud	1.313Inches ± 0.010	1.323 1.303	1.310"	

8	Stud	0.125Inches ± 0.010	0.135 0.115	
9	Stud	0.772Inches ± 0.010	0.782 0.762	
10	Stud	0.563Inches ± 0.010	0.573 0.553	Radius

Plex 5/8/18 10:22 AM Dart.lajeunesse.marie

DQA: _____ Date: _____ WORK ORD
QA Closed: _____ Date: _____

Work Order: _____		DISPOSIT	
Part No. _____		U	
NCR No. _____		Suspected Unaf	
Date : _____	Step #: _____		
Description Work Order Deviation			



Container No: S097749



Part: D2374
Job No: 177172
Serial No/Batch: S097749
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

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Date: 07/31/18

Approval

Root Cause		FAULT CATEGORY											
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong								
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions								
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance								
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect								
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing								
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved								
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing								
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish								
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread								
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence								
Past Expiry Date	Manufacturing Process												
Misidentified	Past Due												
OTHER :													